

# Work Order ID 74611 - 2

Monday, October 03, 2011 4:04:16 PM

Item ID:

D3195-041

Revision ID:

Reference:

Approvals:

Bracket Assembly Item Name:

Start Date: Required Date: 10/5/2011

10/3/2011

Start Qty: 6.00

Req'd Qty: 6.00

QC:

Process Plan:

Operation Description

Work Center ID Revision Nbr Draw Nbr

D3195

Sequence ID/

Rev A

100

BAND SAW

Bandsaw Jeaspa Bandsaw Accept

Date://-/024

Date:



Setup Start

Stop



Cust Item ID:

Customer:

Date:

Date:

Start Run

Stop

Set Up/ Run Hours

Tool ID

Tool# Plan Accept Code Qty

Reject Qty

Insp. Reject Number Stamp

0.00

Tooling:

SPC (Y/N):

0.00

Cut blanks: (0.75" x 2.00") x 3.60" long

11-10-12

0.00

110

HAAS I HAAS CNC vertical machine #1 HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1 Deburr

120 The state of the state of QC2- Inspect parts off machine FAI/FAIB

0.00

JL 1884 11-10-14

Memo

0.00

Dart	Aeros	pace	Ltd

Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Corrective Action Section B Verification Approval Approval Approval Approval Approval	W/O:			W	ORK ORDER CHANG	ES				
Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:	DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Chief Eng /	Approval QC Inspector
Resolution:										
Resolution:										
Resolution:							-		-	
Resolution:										
Resolution:										
NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Section B Section C	Part No		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date:	
DATE STEP Description of NC Section A Section B Section B Section C Section A Section C Section		R	esolution:	Disposition	on:	QA: N/C Clo	sed:		Date: _	
DATE STEP Description of NC Section A Initial Action Description Sign & Vertication Approval	NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)	)			
Section A Initial Action Description Sign & Section C Chief Eng OC Inspe	DATE	STED	Description of NC				Verific	cation	Approval	Approval
	DAIL	SILF			Action Description Chief Eng		Secti	on C	Chief Eng	QC Inspector

### Work Order ID 74611

Monday, October 03, 2011 4:04:16 PM



Item ID:

D3195-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Bracket Assembly

10/3/2011 Start Qty: 6.00 Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals: Process Plan:

Required Date: 10/5/2011

Date:

Tooling:

Date:

Run Start

OC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

Req'd Qty: 6.00

QC8- Inspect parts - second check

Memo

Memo

Set Up/ Run Hours

0.00

10 / 11/10/14

Tool# Plan

Code

Accept Qty

Reject Reject Oty Number

Insp. Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

0.00

6x & m. fu/10/17

150

Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

Memo START TIME: 32) OFFINISH TIME:

X6m-f11/10/19

W118460

Dart Aerospace L	.td
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	:	QA: N/C	Closed:		Date:	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section	1000000	Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector

### Work Order ID 74611

Monday, October 03, 2011 4:04:16 PM



Page 3

Item ID:

D3195-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 10/5/2011

Bracket Assembly

Start Date:

10/3/2011

Start Qty: 6.00

Reg'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

Date:

Start

OC:

SPC (Y/N):

Date:

Stop

Run

Sequence ID/ Work Center ID

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

G DR 11-10-19.

170

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

0.00

1-Lightly Sand bonding surface 2-Bond D3195-5 into D3195-1 as per Dwg. D3195 A/RContact Cement

SCOTCH-WELD

QC5- Inspect part completeness to step on W/O

HIGH PERFORMACE 3M 1300/1300L

180

Quality Control

Memo

0.00 5 1/13/19

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Dart	Aerospace	Ltd
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W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Frod Wgr	
Part No	:	PAR #:	Fault Car	tegory:	NCR: Ye	s No DO	QA:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Closed: _		Date: _	
NCR:		1	WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC	Corrective Action Section B			Verif	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng			Sign & Section C		Chief Eng	QC Inspector
			-						
			III.						
1	1								1

### Work Order ID 74611

Monday, October 03, 2011 4:04:16 PM

Page 4

Item ID:

D3195-041

Accept

Setup Start



Revision ID:

Item Name:

Bracket Assembly

Start Date:

10/3/2011

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

QC:

Required Date: 10/5/2011

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Reject

Insp. Number Stamp

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

11/10/2098) MF 11-10-19

Part No: PAR #: Fault Category: NCR: Yes No Date: NCR: Disposition: QA: N/C Closed: Date: NCR:	Dart Ae	rospace	Ltd							
Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:	W/O:			WC	RK ORDER CHANG	GES				-
NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Poproval Approval Approval Approval Action Description Sign & Section C Chief Eng OC Inspec	DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Chief Eng /	Approval QC Inspector
Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Approva										
NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP  Description of NC Section A Approval Approval Approval Approval Action Description Sign & Section C Chief Eng OC Inspec	Part No									
DATE STEP Description of NC Section A Section B Section B Section C Section A Section C Section		H	esolution:	Disposition	1:	QA: N/C (	losed:		Date: _	
DATE STEP Description of NC Section A Initial Action Description Sign & Verification Approval Approval Approval Chief Eng OC Inspec	NCR:		ž.	WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
Section A Initial Action Description Sign & Section C Chief Eng OC Inspec			Description of NC		Corrective Action Sec	ction B	Vorifi	ication	Approval	Approval
	DATE	STEP					& Sec		Dec 11 20 11 20 11 20 20 20 20 20 20 20 20 20 20 20 20 20	QC Inspector

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Ammrovol	Annuaval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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DART AEROSPACE LTD	Work Order:	74611
Description: Bracket	Part Number:	D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

		X First Art	icle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.265	+/-0.010	1.265	/		VELA SI-3	
0.242	+/-0.010	244	/		· ·	
1.084	+/-0.010	1.084	/		H-Cz .	
R0.200	+/-0.010	-200	/		11.33	
R0.377	+/-0.010	-377	/			
Ø0.277	+0.005/-0.000	.211	/	D1		
2.677	+/-0.005	2614	/	34	1	
3.432	+/-0.010	3 433	/		r	
0.754	+/-0.010	755	1			
1.387	+/-0.010	1.383	1		i.e.	
0.500	+/-0.010	.499	/			
0.250	+/-0.005	-249	/		- 2	
1.754	+/-0.010	1.753	/		•	
Ø0.191	+0.005/-0.000	191			<i>y</i>	
		Y				

Measured by:	- 1	Audited by: E A	Prototype Approval:	N/A
Date:	11-10-14	Date: ////0//-	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.04.20	New Issue	(P/O D412-702-011/-13)	KJ/RF	-14

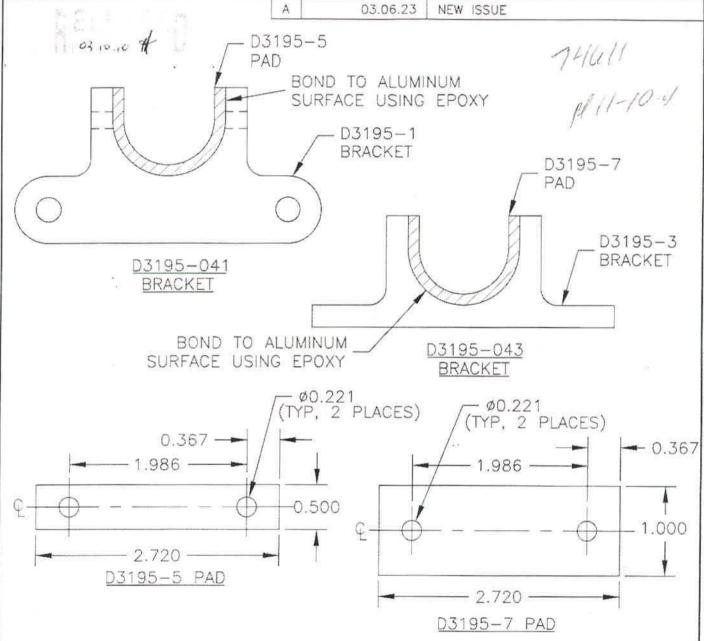
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W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,							
Part No	:	PAR #:	Fault Categ	jory:	NCR: Y	es No	o DQ	A:	_ Date: _	
	Res	solution:	Disposition	ı:	QA: N/C	Clos	ed:		_ Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			ction B		Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Secti		Chief Eng	QC Inspector
			Ž.							





DESIGN P	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE	100	TITLE	SCALE
03.06.23		BRACKET	1:1



D3195-5 & D3195-7 PAD

MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK (POSSIBLE SUPPLIERS, ACCURATE RUBBER)

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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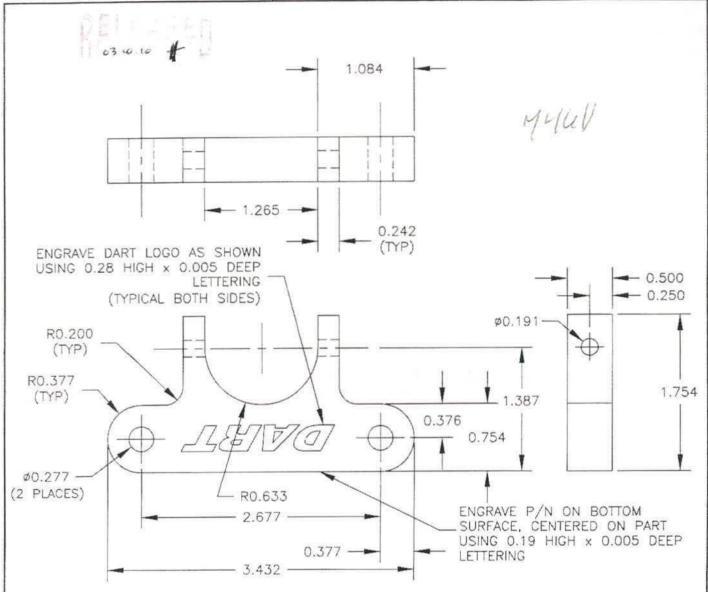
Dart Aerospace Ltd	ł
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W/O:			W	ORK ORDER CHANG	ES				,
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA: N/C	Closed:		Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Dat	e Sect	ion C	Chief Eng	QC Inspector





DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE		TITLE	SCALE
03.06.23		BRACKET	1:1



### D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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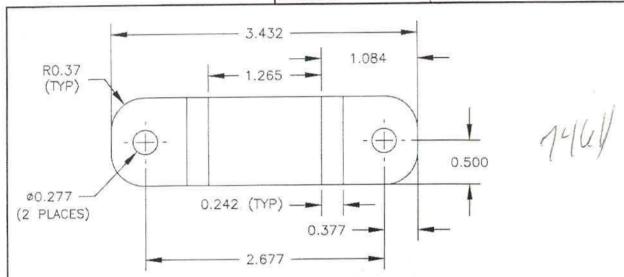
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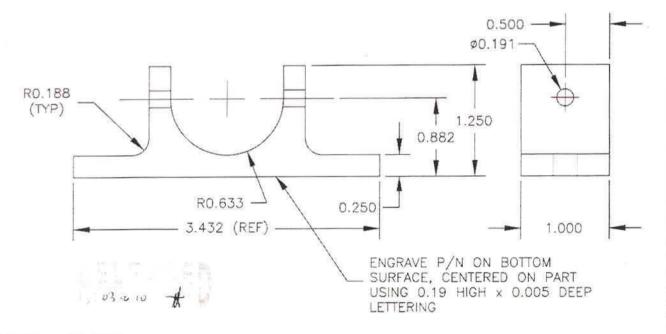
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:		_ Date: _	
	Re	solution:	Disposition	:	QA: N/C Cld	sed:		_ Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
		Description of NC		Corrective Action Section B		Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector



DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	_ APPROVED	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE	1000	TITLE	SCALE
03.06.23		BRACKET	1:1





### D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aeros	space Ltd
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W/O:			WORK ORDER C	HANGES				*
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-		
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date:	

	Reso	olution:	Disposition	1:	QA: N/C Clos	sed:	Date:		
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR)				
		Description of NC	Corrective Action Section B		Verification		Approval	A to a way as	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
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000									
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